

150

DART AEROSPACE LTD	Work Order:	21828
Description: Float Assembly	Part Number:	D3218-041
Dwg: D3218 Rev. A	Qty:	6
D3218-041 replaces Helitech P/N: 358-008-001		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	04.11.02	6
2	PG	Order bags in multiples of 3 Issue P/O: <u>2007075</u> Supplier: Tulmar Safety Systems D3218-041 Float Assembly per Dwg D3218 Serial No.: BXXXXX-01, BXXXXX-02, etc. Copy of inspection paperwork is required with each Float Assembly	U	04.11.03	6
3	RG	Receive and Inspect for transit damage Ensure inspection paperwork is provided with each Float Assembly	CL	04/12/07	6
4	QC5	Review vendor paperwork for completeness - Ensure all pressure tests passed - Ensure all dimensions within tolerance - Ensure Dart inspection performed - Ensure s/n printed on bag matches paperwork/Dart W/O Visually inspect bag for defects - No de-lamination or puckering of seams - Girt attachment OK - No holes through stitching - No excess glue - Valves installed in proper locations	RD	05.01.06	6
5	ST	Re-package and Stock in Kwik Float cell	CL	05/01/12	6
6	AC	Cost / part <u>2276.08</u>	JGC	05.01.13	6
7	DC	Close W/O <u>2276.08</u> Inspect Level 21	HJ	05.01.14	6

Rev	Date	Change	Revised By	Approved
A	03.11.14	New issue	KJ/DS	HJ

RELEASED

03.11.19 HJ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3218	REV. A SHEET 1 OF 2
DATE 03.10.06		TITLE FLOAT ASSEMBLY	SCALE NTS
A	03.10.06	NEW ISSUE	

RELEASED

03.12.05

D3218-041 FLOAT ASSEMBLY, NOTES:

1) MATERIAL:

ITEM	DESCRIPTION	QTY
FABRIC	POLYURETHANE COATED, PENNEL 987-123 YELLOW	7.20 m
ADHESIVE	SEALREZ S-0345 A/B	2.50 L
WEBBING	LAGRAN #3003, 1" WHITE NYLON	0.31 m
THREAD	NYLON, TWISTED TYPE II, SIZE F, CLASS A, V-T-295, COLOR TAN, CSB 92, COLOR #53	5.00 yds
NYLON CORD	MIL-C-5040 TYPE III, COLOR NATURAL	1.60 m
LETTERING	COATES SCREEN C99 S170 BLACK, HIGH GLOSS	0.50 oz
INFLATION VALVE	MIRADA B-51016 / A-51265	2
PRESSURE RELIEF VALVE	MIRADA B-51019	2
TOPPING VALVE	MIRADA B-51209	2
FLANGE	MIRADA B-51014-N (4.25")	4
FLANGE	HALKEY ROBERTS 981001020 (3.5")	2

2) AFTER MANUFACTURE:

- PRESSURE TEST EACH CHAMBER TO 4.36 PSI (30 kPa) FOR 5 MINS.
- INFLATE TO RELIEF VALVE PRESSURE [MIN OF 3.00 PSI (20.6 kPa)]. RELIEF VALVE MUST OPEN AT 3.3-3.5 PSI AND MUST CLOSE AT NOT LESS THAN 3.00 PSI. BAG MUST MAINTAIN A MIN PRESSURE OF 1.6 PSI (11.0 kPa) FOR 24 HOURS.

3) FLOAT IDENTIFICATION LETTERING 0.313" (7.95mm) HIGH BLACK CAPITAL LETTERS STENCILED ON THE R/H SIDE OF THE FLOAT BAG AS FOLLOWS:

DART AEROSPACE LTD.

FLOAT ASSEMBLY

P/N D3218-041

S/N BXXXXX-XX

REPLACES HELITECH P/N 358-008-001

SHOP COPY

**RETURN TO
ENGINEERING**

- COATED SIDE OF FABRIC ON OUTSIDE OF BAG.
- ALL DIMENSIONS ARE IN INCHES. CRITICAL DIMENSIONS (DENOTED BY (E)) MUST BE OBTAINED AT 2 PSI.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY

**SUBJECT TO AMENDMENT
WITHOUT NOTICE**

WORK ORDER

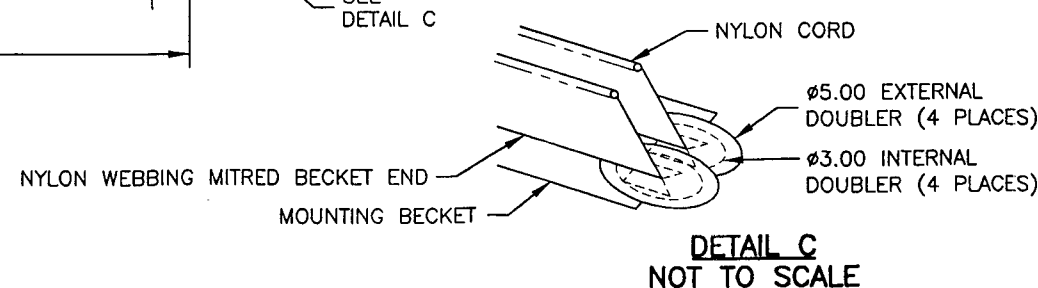
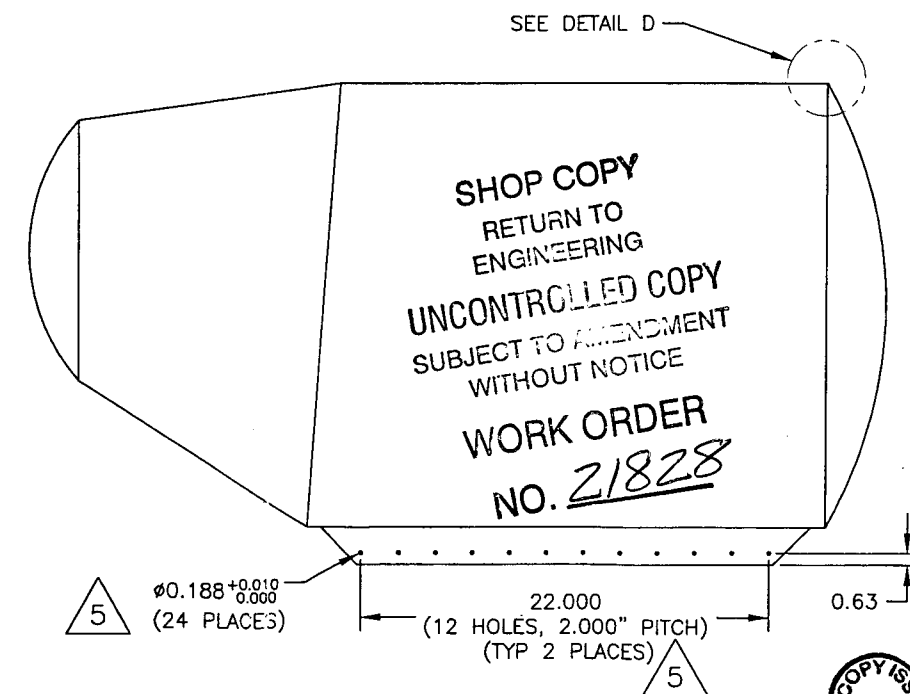
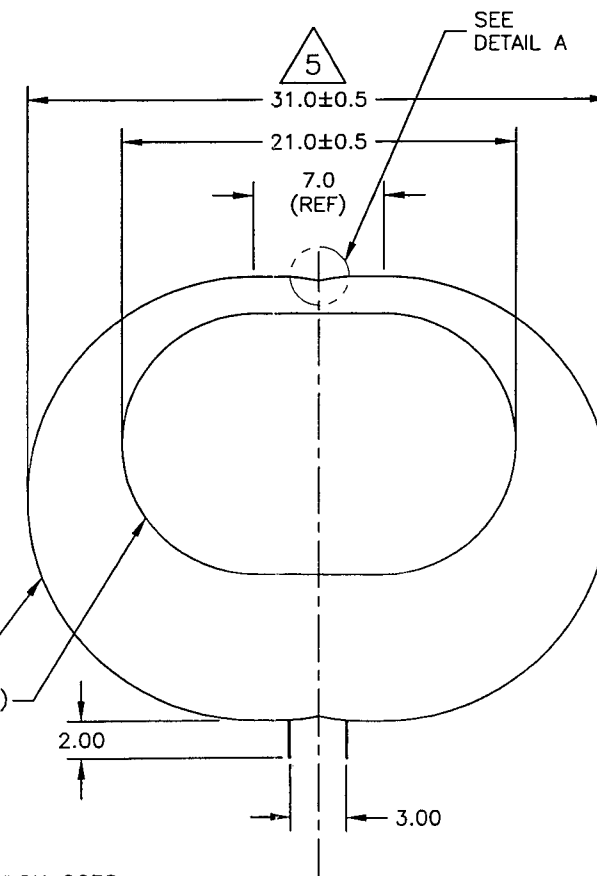
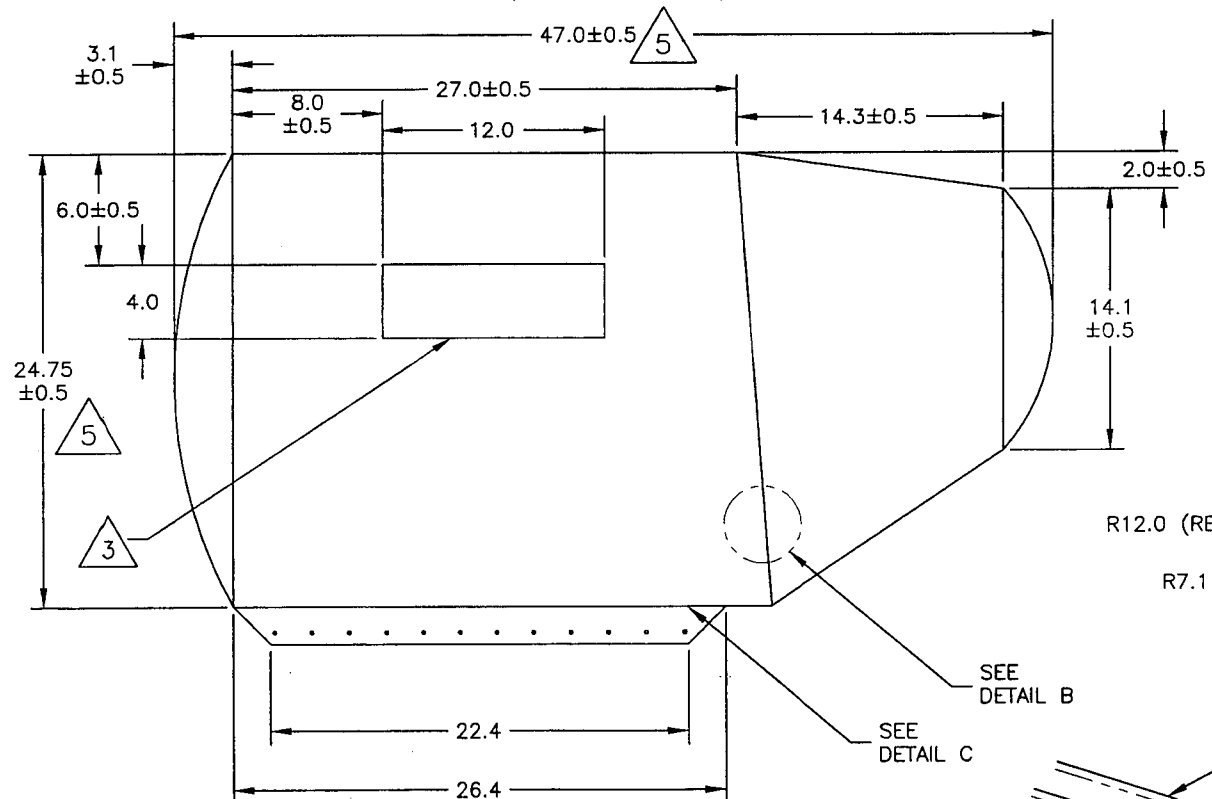
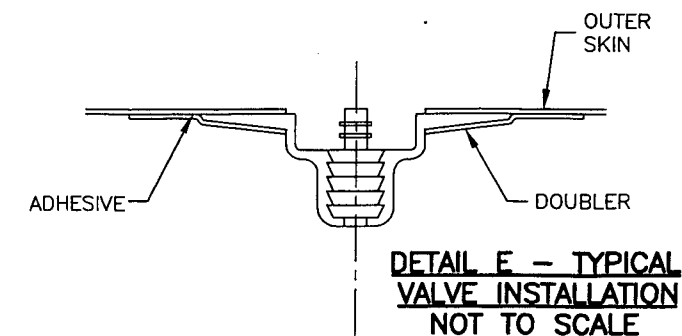
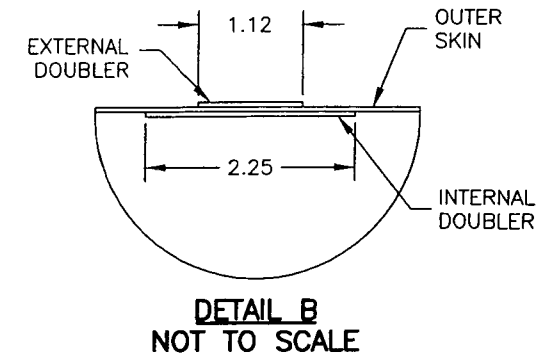
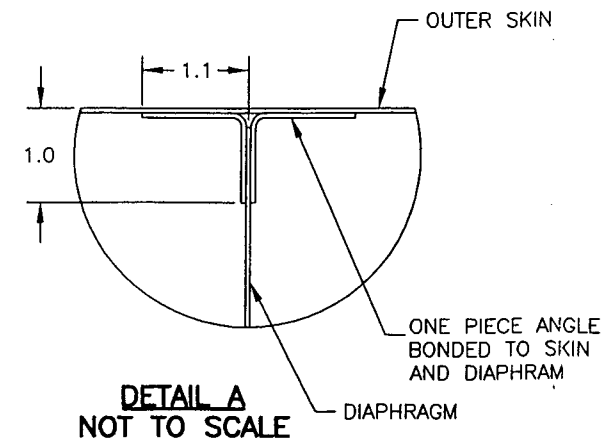
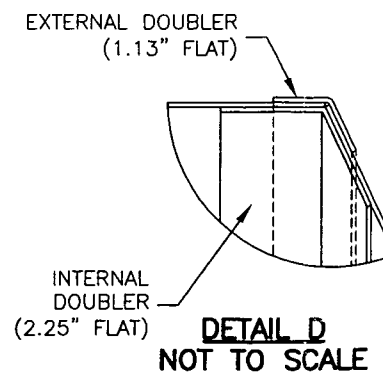
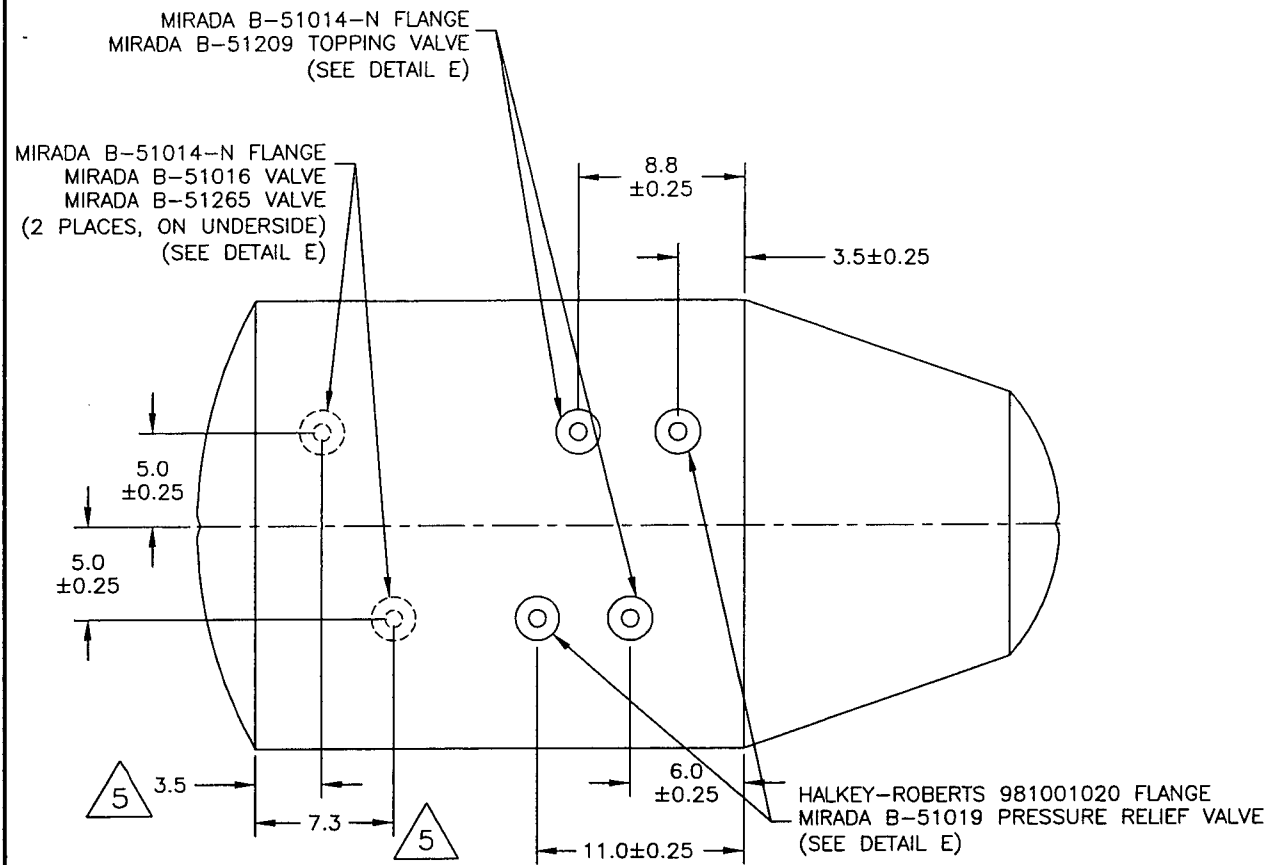
NO. 21828

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RELEASED

03.12.05



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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
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DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3218	REV. A SHEET 2 OF 2
DATE 03.10.06		TITLE FLOAT ASSEMBLY	SCALE 1:10

100% COPY ISSUED

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 02, 2004
02:36 pm

Work Order No : 0021828
Project Name : D3218-041
Project For : WK450
Work Order Type : Main
Main WO Number :
House Part Number : D3218-041
Description : Float Assembly
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 11-02-04
Est Finish Date : 12-03-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

TULMAR

Packing Sheet

TULMAR SAFETY SYSTEMS

Revision 1/10/96 Form 457

1123 Cameron Street

Hawkesbury, Ontario, Canada

K6A 2B8

TEL: (613) 632-1282

FAX: (613) 632-2030

Sold To

Shipped To

DART AEROSPACE LTD

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

Tel: 613-632-9577

Date	Your Order No.	Shipped Via	No. Containers	Gross Weight	Reference No.
12/6/2004	2007075	Our Truck	1 <i>Box</i>	kg	W/O 14699 P/S 10190

Part No.	Item	Quantity	Qty Shipped	Balance	Description	Release No.
TSS8927	1.	0	0	0	FLOAT ASSY, individual bag P/N D3218-041 Rev A S/N: B21828-01, B21828-02, B21828-03, B21828-04, B21828-05, B21828-06 Release Note: R92-10070	
		6	6	0		
		0	0	0		
		0	0	0		
		0	0	0		
		0	0	0		
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		0	0	0		
		0	0	0		
		0	0	0		
		0	0	0	DART AEROSPACE LTD	

SHIPPER


Daniel Gelineau

TULMAR

Release Note

Revision 05/08/01 Form 458

TULMAR SAFETY SYSTEMS INC.

1123 Cameron Street,

Hawkesbury, Ont. Canada K6A 2B8

Tel: (613)632-1282

Fax: (613)632-2030

R/N No. **R92-10070**Date: **12/6/2004**

Sold To:

Shipped To:

DART AEROSPACE LTD

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

Your Order	Conveyance	Our Order No.	P/S No.
2007075	Our Truck	14699	10190

Item	Description	Qty Ordered	Spec'n No.	Qty Shipped	Incoming Release No.	Batch
1.	FLOAT ASSY, individual bag	6	TSS8927	6		
	P/N D3218-041 Rev A	0				
	S/N: B21828-01, B21828-02, B21828-03,	0				
	B21828-04, B21828-05, B21828-06	0				
		0				
		0				
		0				
		0				
		0				
		0				
		0				
		0				
		0				
		0				
		0				
	If any questions or concerns please contact	0				
	Linda Presseault, QA Mgr 613-632-1282.	0				
		0				
		0				

I hereby certify that the items listed hereon have been inspected, tested, and conform to all specifications and requirements detailed in the contract or purchase order.



Authorized Inspector

12/6/2004

Date

TULMAR

Order No 14699 Order Date 5-Nov-04 Page 1

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030

Customer Purchase Order
2007075

Contact:

Bill To

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CA

Ship To

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CA

Dear Customer,
This document acknowledges receipt of your order. Please review the information presented here and advise us of any errors you notice or disagreements you have at your earliest convenience. For fastest service, write or call us at the address and phone number printed above. Please refer to our Order Number and your P.O. Number in all correspondence.

Customer

CDART100

Payment Terms Ship Via

Net 30 Days
Pick-Up

PPD/COL

Shipping Instructions

FOB HAWKESBURY

Item No	Ship Date	Quantity	UOM	Unit Price	Extended Price
---------	-----------	----------	-----	------------	----------------

8927	3-Dec-04	6	EA		
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Float Assembly, individual bag

P/N: D3218-041

P/N: D3218-041

Revision A

Must use Sealrez S-0345A/B adhesive.

S/O: B01848 - 01/02/03/04/05/06

ASSN No. 23.04 SBL

6 Dec-6/04
P

B 21828 - 01

- 02

- 03

- 04

- 05

- 06

S/F: 3663

Sales amount:

Sales tax:

Total

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

W/O: 3663 TSS P/N: 8927 Qty.: 1 Customer P/N: D3218-041 Dwg. No.: D3218 Rev.: A Date: Nov. /04

Cutting IAW PCS 003		Marking IAW PCS 004		Bonding IAW PCS 002		Silkscreen	
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
85	Nov /04	125 157	Nov -04	(Documented below)			

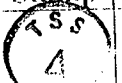

* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
1- a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint) ± 1/8"	37 10 Nov. 04	7104-24	1	-	-	1	9	Nov. 10/04
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	37 10 Nov. 04	Bonding	6	-	-	6	11	Nov. 10/04
c) Attach (6) Doublers on above Flanges	37 10 Nov. 04		6	-	-	6	9	Nov. 10/04
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	37 10 Nov. 04	7104-24	1	-	-	1	9	Nov. 10/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 10 Nov. 04	Bonding	1	-	-	1	9	Nov. 10/04
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	117 10 Nov 04	7104-24	1	-	-	1	9	Nov 10/04
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	117 Nov 04	7104-25	1	-	-	1	9	Nov 11/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 Nov 16/04	Testing (see sheet 2)	1	-	-	1	4	Nov 16/04
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	37 17 Nov. 104	7104-25	1	-	-	1	9	Nov 17/04
b) Attach ID Patch (ref. CAR 04-003)	37 Dec 3/04	Bonding	1	-	-	1	9	Dec 3/04
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12 Nov 22/04	Testing (see sheet 2)	1	-	-	1	4	Nov 22/04
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	37 Nov. 23/04	Bonding	1	-	-	1	11	Nov. 23/04
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	37 Nov-23/04		1	-	-	1	11	Nov 24/04
c) Attach 5" split patch on each end (x 4)	37 Nov 23/04		1	-	-	1	11	Nov 24/04

CULMAR

Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch: Serial No.: B <u>21828-01</u> & Inspection Stamp beside the S/N <u>21828-01</u>	<u>12 Nov 30/04</u> <u>12 Dec 6/04</u>	Testing (see sheet 3)	<u>1</u> <u>1</u>	<u>-</u> <u>-</u>	<u>-</u> <u>-</u>	<u>1</u> <u>1</u>	 	<u>Nov 30/04</u> <u>Dec 6/04</u>
Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high lettering and black ink: serial number (7 digits), provided by DART (refer to W/O). * Verify the integrity of the Valves (Threads/gaskets).								

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams.

Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94 PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase + 0.054 PSI for each 1°C of temperature decrease
+ 0.049 PSI for each 0.1 inch of barometric increase - 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	45 Minute Stabilizing Period			1 Hour Test										Final Read'g	Pass / Fail
		Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.					
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	1:45	2:30	3.00 PSI	2:30	3:30	3.00 PSI	24	24	30.14	30.14	<div><div></div><div></div></div>	3.00 PSI	Pass	
Re-Test																	
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	8:20	9:05	3.00 PSI	9:05	10:05	2.96 PSI	21	21	29.94	29.94	<div><div></div><div></div></div>	2.96 PSI	Pass	
Re-Test																	

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature: not applicable AP Date: _____

Observations: _____

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief Valve Test	PRV Serial Numbers	Opening		Closing		Pass / Fail
		Time ON	Pressure	Time	Close	
Chamber # 1	32856	12:55	3.50 PSI	12:58	3.07 PSI	Pass
Chamber # 2 (Main Seam)	32865	1:00	3.42 PSI	1:05	3.19 PSI	Pass

Chambers	Design (closing) Pressure as per above	24 Hour Leakage Test								22% Hum.		
		Time On	Time Off	Read'g	Temp. Start/End		Barom. Start/End		Adjust.		Final Read'g	Pass Fail
Nov 25/04	Nov 26/04											
# 1	3.07 PSI	12:58	12:58	2.18 PSI	23°	22°	29.10	29.80	-0.054 +0.343	2.46 PSI	Pass	
Re-Test												
# 2 (Main Seam)	3.19 PSI	1:05	1:05	1.40 PSI	22	22	29.80	30.05	+0.122 +0.054 -0.004	1.52 PSI	Fail	
Nov 30/04	Nov 30/04	8:30	8:30	1.94	23	22	30.07	30.06		1.98	Pass	

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3 1/2	Pass	47.0	± 0.5	46 7/8		24.75	± 0.5	25	Pass
7.3	± 0.100 *	7 1/2	Pass					31.0	± 0.5	31	Pass

* = IAW OSI 018, rev. A dated 03-05-29

Submission of Adhesive Testing:

Peel	24 hour	Subm. Date / am/pm	Pass/Fail	Subm. Date / am/pm	Pass/Fail	Subm. Date / am/pm	Pass/Fail	Subm. Date / am/pm	Pass/Fail
		Nov 10/04	Pass	Nov 17/04	Pass	Nov 23/04	Pass		
Shear	7 day	Nov 10/04	Pass	Nov 17/04	Pass	Nov 23/04	Pass		
		Nov 10/04	Pass	Nov 17/04	Pass	Nov 23/04	Pass		
24 hour	7 day	Nov 10/04	Pass	Nov 17/04	Pass	Nov 23/04	Pass		
		Nov 10/04	Pass	Nov 17/04	Pass	Nov 23/04	Pass		

TULMAR

#2

Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 1 of 3

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

W/O: 3663 TSS P/N: 8927 Qty.: 1 Customer P/N: D3218-041 Dwg. No.: D3218 Rev.: A Date: Nov/04

Cutting IAW PCS 003		Marking IAW PCS 004		Bonding IAW PCS 002		Silkscreen	
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
85	Nov/04	125-157	11-04	(Documented below)			

* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3.3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
1- a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint) ± 1/8"	37 Nov. 11/04	7104-25 Bonding	1	—	—	1		Nov. 11/04
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	± 90 - Nov. 10/04		6	0	—	6		Nov. 10/04
c) Attach (6) Doublers on above Flanges	90 - Nov. 10/04		6	—	—	6		Nov. 10/04
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	37 Nov. 11/04	7104-25 Bonding	1	—	—	1		Nov. 11/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 Nov. 11/04		1	—	—	1		Nov. 11/04
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	117 11 Nov 04		1	—	—	1		Nov. 11/04
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	117 11 Nov 04	7104-25 Bonding	1	—	—	1		Nov. 11/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 16 Nov 04		1	—	—	1		Nov. 16/04
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	37 16 Nov. 04		1	—	—	1		Nov. 16/04
b) Attach ID Patch (ref. CAR 04-003)	37 Dec 3/04	7104-25 Bonding	1	—	—	1		Dec 3/04
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12 Nov 22/04		1	—	—	1		Nov. 22/04
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	37 Nov. 22/04		1	—	—	1		Nov. 23/04
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	37 Nov 24/04	7104-25 Bonding	1	—	—	1		Nov. 24/04
c) Attach 5" split patch on each end (x 4)	37 Nov 24/04		1	—	—	1		Nov 24/04

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch: Serial No.: B <u>21828-02</u> & Inspection Stamp beside the S/N <u>21828-02</u>	<u>12 Nov 27/04</u>	Testing (see sheet 3)	1	-	-	1	4	<u>Nov 27 2004</u>
	<u>12 Dec 6/04</u>		1	-	-	1	4	<u>Dec 6/2004</u>

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16" high lettering and black ink: serial number (7 digits), provided by DART (refer to W/O). * Verify the integrity of the Valves (Threads/gaskets).

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams.

Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94 PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
+ 0.049 PSI for each 0.1 inch of barometric increase

+ 0.054 PSI for each 1°C of temperature decrease
- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	45 Minute Stabilizing Period			1 Hour Test									15 %.	
		Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End		Barom. Start/End		Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI	Fail	3.00 PSI	—	—	3.00 PSI	—	—	— PSI	—	—	—	—	—	—	—
Re-Test		Pass	3.00 PSI	9:15	10:00	3.00 PSI	10:00	11:00	2.97 PSI	24	24	30.16	30.14	-0.02	2.96 PSI	Pass
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	8:15	9:00	3.00 PSI	9:00	10:00	2.99 PSI	21	21	29.94	29.94	—	2.99 PSI	Pass
Re-Test																

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature: Not applicable A.P. Date: _____

Observations: _____

ULMAR

#2

Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2). The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief Valve Test	PRV Serial Numbers	Opening		Closing		Pass / Fail
		Time ON	Pressure	Time	Close	
Chamber # 1	32853	12:45	3.34 PSI	12:50	3.09 PSI	Pass
Chamber # 2 (Main Seam)	31660	12:50	3.44 PSI	12:55	3.22 PSI	Pass

Chambers	Design (closing) Pressure as per above	24 Hour Leakage Test								22 % humidity	
		Time On	Time Off	Read'g	Temp. Start/End		Barom. Start/End		Adjust.	Final Read'g	Pass Fail
Nov 25/04											
# 1	3.09 PSI	12:50	12:50	2.22 PSI	23 ^c	22 ^c	29.10	29.79	-0.054 +0.338	2.49 PSI	Pass
Re-Test											
# 2 (Main Seam)	3.22 PSI	12:55	12:55	1.76 PSI	22 ^c	22	29.80	30.05	+0.122	1.88 PSI	Pass
Re-Test											

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3.5	Pass	47.0	± 0.5	46 7/8	Pass	24.75	± 0.5	25 1/16	Pass
7.3	± 0.100 *	7.5	Pass					31.0	± 0.5	31 1/4	Pass

* = IAW QSI 018, rev. A dated 03-05-29

Submission of Adhesive Testing:

		Subm. Date / am (pm)	Pass/Fail	Subm. Date / am (pm)	Pass/Fail	Subm. Date / am (pm)	Pass/Fail	Subm. Date / am (pm)	Pass/Fail
	Peel								
	24 hour	Nov 10/04	Pass	Nov 11/04	Pass	Nov 16/04	Pass	Nov 22/04	Pass
	7 day	Nov 10/04	Pass	Nov 12/04	Pass	Nov 16/04	Pass	Nov 22/04	Pass
	24 hour			Nov 14/04	Pass	Nov 16/04	Pass	Nov 22/04	Pass
	7 day			Nov 11/04	Pass	Nov 16/04	Pass	Nov 22/04	Pass
	Shear								

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief Valve Test	PRV Serial Numbers	Opening		Closing		Pass / Fail
		Time ON	Pressure PSI	Time	Close PSI	
Chamber # 1						
Chamber # 2 (Main Seam)						

Chambers	Design (closing) Pressure as per above	24 Hour Leakage Test							
		Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1	PSI			PSI				PSI	
Re-Test									
# 2 (Main Seam)	PSI			PSI				PSI	
Re-Test									

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	+ 0.100 *			47.0	+ 0.5			24.75	+ 0.5		
7.3	+ 0.100 *							31.0	+ 0.5		

* = IAW QSI 018, rev. A dated 03-05-29

Submission of Adhesive Testing:

		Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail
Peel	24 hour	Nov 24/04	Pass						
	7 day	Nov 24/04	Pass						
Shear	24 hour	Nov 24/04	Pass						
	7 day	Nov 24/04	Pass						

#3

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

W/O: 3663 TSS P/N: 8927 Qty.: 1 Customer P/N: D3218-041 Dwg. No.: D3218 Rev.: A Date: Nov/04

Cutting IAW PCS 003		Marking IAW PCS 004		Bonding IAW PCS 002		Silkscreen	
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
85	Nov/04	25-157	Nov/04	(Documented below)			

* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint) ± 1/8" b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up c) Attach (6) Doublers on above Flanges	37 11 Nov 04 #20 Nov/04	Bonding 7104-25	1	-	-	1	1	Nov 11/04
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	37 11 Nov 04		1	-	-	1	TSS 11	Nov 11/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 11 Nov 04		1	-	-	1	11	Nov 11/04
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	117 11 Nov 04	7104-25	1	-	-	1	11	Nov 11/04
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	117 12 Nov 04	7104-25	1	-	-	1	11	Nov 12/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 15 Nov 04	Testing (see sheet 2)	1	-	-	1	4	Nov 15/04
7- a) Closure of 1" Main Seam (overlap) ± 1/8" b) Attach ID Patch (ref. CAR 04-003)	37 16 Nov 04 37 Dec 3/04	7104-25 Bonding	1	-	-	1	4	Nov 16/04 Dec 3/04
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12 Nov 22/04	Testing (see sheet 2)	1	-	-	1	4	Nov 22/04
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8" b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag c) Attach 5" split patch on each end (x 4)	37 Nov 23/04 37 Nov 24/04 37 Nov 24/04	7104-25 Bonding 7104-25	1 1 1	- - -	- - -	1 1 1	4 11	Nov 23/04 Nov 24/04 Nov 24/04

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#3

Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch: Serial No.: B <u>21828-03</u> & Inspection Stamp beside the S/N	<u>12 Nov 04</u>	Testing (see sheet 3)	<u>1</u>	<u>-</u>	<u>-</u>	<u>1</u>	<u>4</u>	<u>Nov 27 2004</u>
	<u>12 Dec 6 2004</u>		<u>1</u>	<u>-</u>	<u>-</u>	<u>1</u>	<u>4</u>	<u>Dec 6 2004</u>

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16" high lettering and black ink: serial number (7 digits), provided by DART (refer to W/O). * Verify the integrity of the Valves (Threads/gaskets).

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams.

Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94 PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
+ 0.049 PSI for each 0.1 inch of barometric increase

+ 0.054 PSI for each 1°C of temperature decrease
- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	45 Minute Stabilizing Period			1 Hour Test										15 %
		Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail		
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	1:45	2:30	3.00 PSI	2:30	3:30	3.00 PSI	24	24	30.20	30.20	0	3.0 PSI	Pass
Re-Test																
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	8:10	8:55	3.00 PSI	8:55	9:55	3.0 PSI	21	21	29.94	29.94	-	3.0 PSI	Pass
Re-Test																

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature: not applicable

Date: _____

Observations: _____

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief Valve Test		Opening			Closing			Pass/Fail
Chamber #	PRV Serial Numbers	Time ON	Pressure		Time	Close		
Chamber # 1	32861	12.55	3.44 PSI		1.00	3.24 PSI		Pass
Chamber # 2 (Main Seam)	32855	1.05	3.45 PSI		1.10	3.28 PSI		Pass

Chambers	Design (closing) Pressure as per above	24 Hour Leakage Test								22 % Runy	
		Time On	Time Off	Read'g	Temp. Start/End		Barom. Start/End		Adjust.	Final Read'g	Pass/Fail
Nov-25/04											
# 1	3.24 PSI	1:00	1:00	2.51 PSI	23 [°]	22 [°]	29.10	29.80	-0.059 +0.343	2.79 PSI	Pass
Re-Test											
# 2 (Main Seam)	3.28 PSI	1:10	1:10	2.04 PSI	22 [°]	22 [°]	29.80	30.05	+0.120	2.16 PSI	Pass
Re-Test											

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3.5	Pass	47.0	± 0.5	47.48	Pass	24.75	± 0.5	25	Pass
7.3	± 0.100 *	7.3	Pass					31.0	± 0.5	31 1/16	Pass

* = IAW OSI 018, rev. A dated 03-05-29

Submission of Adhesive Testing:

		Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail
Peel	24 hour	Nov 11/04	Pass	Nov 11/04	Pass	Nov 12/04	Pass	Nov 16/04	Pass
	7 day	Nov 11/04	Pass	Nov 11/04	Pass	Nov 12/04	Pass	Nov 16/04	Pass
Shear	24 hour	Nov 11/04	Pass	Nov 11/04	Pass	Nov 12/04	Pass	Nov 16/04	Pass
	7 day	Nov 11/04	Pass	Nov 11/04	Pass	Nov 12/04	Pass	Nov 16/04	Pass

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The-corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief Valve Test	PRV Serial Numbers	Opening		Time	Closing		Pass/Fail
		Time ON	Pressure		Close	PSI	
Chamber # 1			PSI			PSI	
Chamber # 2 (Main Seam)			PSI			PSI	

Chambers	Design (closing) Pressure as per above	24 Hour Leakage Test							
		Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust	Final Read'g	Pass/Fail
# 1	PSI			PSI				PSI	
Re-Test									
# 2 (Main Seam)	PSI			PSI				PSI	
Re-Test									

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *			47.0	± 0.5			24.75	± 0.5		
7.3	± 0.100 *							31.0	± 0.5		

* = IAW QSI 018, rev. A dated 03-05-29

Submission of Adhesive Testing:

		Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail
Peel	24 hour	Nov 24/04	Pass						
	7 day	Nov 24/04	Pass						
Shear	24 hour	Nov 24/04	Pass						
	7 day	Nov 24/04	Pass						

Description: Float Bag Assembly

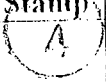

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

W/O: 3663 TSS P/N: 8927 Qty.: 1 Customer P/N: D3218-041 Dwg. No.: D3218 Rev.: A Date: Nov/04

Cutting IAW PCS 003		Marking IAW PCS 004		Bonding IAW PCS 002		Silkscreen	
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
<u>AS</u>	<u>Nov/04</u>	<u>125-157</u>	<u>Nov/04</u>	(Documented below)			

* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3-3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
1- a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint) ± 1/8"	37 15 Nov 04	Bonding	1	—	—	1		Nov 15/04
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	90 Nov 14/04		6	—	—	6		Nov 15/04
c) Attach (6) Doublers on above Flanges	90 Nov 15/04		6	—	—	6		Nov 15/04
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	37 15 Nov 04	7104-25	1	—	—	1		Nov 15/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 15 Nov 04	Bonding	1	—	—	1		Nov 15/04
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	117 15 Nov 04		1	—	—	1		Nov 15/04
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	117 16 Nov 04		1	—	—	1		Nov 16/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 Nov 22/04	Testing (see sheet 2)	1	—	—	1		Nov 22/04
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	37 22 Nov 04	7104-25	1	—	—	1		Nov 22/04
b) Attach ID Patch (ref. CAR 04-003)	37 Dec 3/04	Bonding	1	—	—	1		Dec 3/04
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12 Nov 25/04	Testing (see sheet 2)	1	—	—	1		Nov 25/04
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	37 26 Nov 04	7104-25	1	—	—	1		Nov 26/04
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	37 26 Nov 04	Bonding	1	—	—	1		Nov 26/04
c) Attach 5" split patch on each end (x 4)	37 26 Nov 04		1	—	—	1		Nov 26/04

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch: Serial No.: B21828-04 & Inspection Stamp beside the S/N 21828-04	2 Dec 1/04	Testing (see sheet 3)	1	—	—	1		Dec 1/04
			1	—	—	1		Dec 6/04

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16" high lettering and black ink: serial number (7 digits), provided by DART (refer to W/O) * Verify the integrity of the Valves (Threads/gaskets)

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams.

Inflation Test: Lower Chamber to 3.00 psi , re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94 PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase + 0.054 PSI for each 1°C of temperature decrease
+ 0.049 PSI for each 0.1 inch of barometric increase - 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	45 Minute Stabilizing Period			1 Hour Test								
		Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	8:45	9:30	3.00 PSI	9:30	10:30	3.05 PSI	21° 21	29.93 29.93	—	3.05 PSI	Pass
Re-Test														
# 2 (Main Seam)	4.36 PSI	Fail.	3.00 PSI			3.00 PSI			PSI				PSI	
Re-Test		Pass	3.00 PSI	1:10	1:55	3.00 PSI	2:00	3:00	2.98	23° 23°	29.13 29.14	+0.06	3.04 PSI	Pass

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature: Chris Proulx

Date: 02/11/04

Observations: OK

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 - 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief Valve Test	PRV Serial Numbers	Opening		Closing		Pass / Fail
		Time ON	Pressure	Time	Close	
Chamber # 1	32848	10:30	3.48 PSI	10:35	3.27 PSI	Pass
Chamber # 2 (Main Seam)	32847	10:40	3.46 PSI	10:45	3.19 PSI	Pass

Chambers	Design (closing) Pressure as per above	24 Hour Leakage Test								14 % Leaking	
		Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass	Fail	
Nov 29/04	Nov 30/04										
# 1	3.27 PSI	10:35	10:35	2.02 PSI	22 ^e 22 ^e	30.12 30.04	-0.039	1.98 PSI	Pass		
Re-Test											
Nov 30/04	Dec 1 2004										
# 2 (Main Seam)	3.19 PSI	10:45	10:45	2.37 PSI	22 ^e 22 ^e	30.05 29.19	-0.421	1.94 PSI	Pass		
Re-Test											

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3.50	Pass	47.0	± 0.5	47.0	Pass	24.75	± 0.5	25.25	Pass
7.3	± 0.100 *	7.25	Pass					31.0	± 0.5	31.18	Pass

* = IAW QSI 018, rev. A dated 03-05-29

Submission of Adhesive Testing:

		Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail
Peel	24 hour	Nov 15/04	Pass	Nov 15/04	Pass	Nov 16/04	Pass	Nov 22/04	Pass
	7 day	Nov 22/04	Pass	Nov 22/04	Pass	Nov 16/04	Pass	Nov 22/04	Pass
Shear	24 hour	Nov 15/04	Pass	Nov 15/04	Pass	Nov 16/04	Pass	Nov 22/04	Pass
	7 day	Nov 22/04	Pass	Nov 22/04	Pass	Nov 16/04	Pass	Nov 22/04	Pass

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief Valve Test

PRV Serial Numbers	Opening		Closing		Pass / Fail
	Time ON	Pressure	Time	Close	
Chamber # 1		PSI		PSI	
Chamber # 2 (Main Seam)		PSI		PSI	

24 Hour Leakage Test

Chambers	Design (closing) Pressure as per above								
		Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1	PSI			PSI				PSI	
Re-Test									
# 2 (Main Seam)	PSI			PSI				PSI	
Re-Test									

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *			47.0	± 0.5			24.75	± 0.5		
7.3	± 0.100 *							31.0	± 0.5		

* = IAW QSI 018, rev. A dated 03-05-29

Submission of Adhesive Testing:

		Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail
Peel	24 hour	Nov 26/04	Pass						
	7 day	Nov 26/04	Pass						
Shear	24 hour	Nov 26/04	Pass						
	7 day	Nov 26/04	Pass						

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

W/O: 3663 TSS P/N: 8927 Qty.: 1 Customer P/N: D3218-041 Dwg. No.: D3218 Rev.: A Date: _____

Cutting IAW PCS 003		Marking IAW PCS 004		Bonding IAW PCS 002		Silkscreen	
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
<u>B5</u>	<u>Nov/04</u>	<u>125-157</u>	<u>Nov 1 / 04</u>	(Documented below)			

* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3 of 3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
1- a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint) ± 1/8"	<u>37 15 Nov-04</u>	Bonding	<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Nov. 15/04</u>
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	<u>90 Nov. 15/04</u>		<u>6</u>	<u>—</u>	<u>—</u>	<u>6</u>		<u>Nov. 15/04</u>
c) Attach (6) Doublers on above Flanges			<u>6</u>	<u>—</u>	<u>—</u>	<u>6</u>		<u>Nov. 15/04</u>
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	<u>37 15 Nov. 04</u>	Bonding	<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Nov. 15/04</u>
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	<u>37 15 Nov. 04</u>		<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Nov. 15/04</u>
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	<u>117 16 Nov 04</u>		<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Nov 16 /04</u>
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	<u>117 16 Nov 04</u>	Bonding	<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Nov. 16 /04</u>
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	<u>12 Nov 22/04</u>	Testing (see sheet 2)	<u>1</u>	<u>—</u>	<u>1</u>	<u>1</u>		<u>Nov 22/04</u>
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	<u>Helene Nov 23/04</u>	Bonding	<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Nov. 23/04</u>
b) Attach ID Patch (ref. CAR 04-003)			<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Dec 3/04</u>
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	<u>12 Nov 29/04</u>	Testing (see sheet 2)	<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Nov 29/04</u>
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	<u>37 Nov 28/04</u>	Bonding	<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Nov 30/04</u>
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	<u>37 Nov. 30/04</u>		<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Nov 30/04</u>
c) Attach 5" split patch on each end (x 4)	<u>37 Nov 30/04</u>		<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>		<u>Nov 30/04</u>

Stages & Descriptions	Operator No. + Date	Operation	Accept Qty.	Reject Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch: Serial No.: B <u>21828-05</u> & Inspection Stamp beside the S/N <u>21828-05</u>	<u>12 Dec 3/04</u>	Testing (see sheet 3)	<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>	<u>4</u>	<u>Dec 3 2004</u>
	<u>12 Dec 6/04</u>		<u>1</u>	<u>—</u>	<u>—</u>	<u>1</u>	<u>4</u>	<u>Dec 6 2004</u>

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high lettering and black ink: serial number (7 digits), provided by DART (refer to W/O). Verify the integrity of the Valves (Threads/gaskets).

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C. c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams.

Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94 PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase + 0.054 PSI for each 1°C of temperature decrease
+ 0.049 PSI for each 0.1 inch of barometric increase - 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	45 Minute Stabilizing Period			1 Hour Test									22 % Hum.	
		Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail		
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	12:15	1:00	3.00 PSI	1:00	2:00	3. PSI PSI	22° 22°	29.88	29.88	- / -	3 PSI PSI	Pass	
Re-Test																
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	11:00	11:45	3.00 PSI	11:45	12:45	2.94 PSI	22 22	29.78	29.79	- +0.004	2.94 PSI	Pass	
Re-Test																

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature: Chris P...

Date: 09/11/22

Observations: OK

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief Valve Test	PRV Serial Numbers	Opening		Closing		Pass / Fail
		Time ON	Pressure	Time	Close	
Chamber # 1	32867	9:50	3.50 PSI	9:55	3.30 PSI	Pass
Chamber # 2 (Main Seam)	32849	12:00	3.49 PSI	12:05	3.17 PSI	Pass

Chambers	Design (closing) Pressure as per above	24 Hour Leakage Test								17 % humidity	
		Time On	Time Off	Read'g	Temp. Start/End		Barom. Start/End		Adjust.	Final Read'g	Pass / Fail
Dec 1/04											
# 1	3.30 PSI	9:55	9:55	2.63 PSI	22 ^c	23 ^c	29.24	29.78	+0.054 +0.264	2.94 PSI	Pass
Re-Test											
# 2 (Main Seam)	3.17 PSI	12:05	12:05	2.21 PSI	23 ^c	23	29.78	29.57	-0.102	2.10 PSI	Pass
Re-Test											

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3.5	Pass	47.0	± 0.5	47.3/4	Pass	24.75	± 0.5	25.1/8	Pass
7.3	± 0.100 *	7.3	Pass					31.0	± 0.5	31.0	Pass

* = IAW QSI 018, rev. A dated 03-29

Submission of Adhesive Testing:

		Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail
	Peel								
	24 hour	Nov 16/04	Pass	Nov 29/04	Pass				
	7 day	Nov 16/04	Pass	Nov 29/04	Pass				
	24 hour	Nov 16/04	Pass	Nov 29/04	Pass				
	7 day	Nov 16/04	Pass	Nov 29/04	Pass				

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

W/O: 3863

TSS P/N: 8927

Qty.: 1

Customer P/N: D3218-041

Dwg. No.: D3218

Rev.: A

Date: Nov. 04

Cutting IAW PCS 003		Marking IAW PCS 004		Bonding IAW PCS 002		Silkscreen	
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
285	Nov/04			(Documented below)			

* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3 of 3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint) ± 1/8"	37 17 Nov. 04	Bonding	1	—	—	1		Nov. 17/04
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	37 16 Nov. 04		6	—	—	6		Nov. 16/04
c) Attach (6) Doublers on above Flanges	37 16 Nov. 04		6	—	—	6		Nov. 17/04
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	37 17 Nov. 04	7104-25	1	—	—	1		Nov. 17/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 17 Nov. 04	Bonding	1	—	—	1		Nov. 17/04
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	117 17 Nov. 04		1	—	—	1		Nov 17/04
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	117 18 Nov 04		1	—	—	1		Nov. 18/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 22/Nov/04	Testing (see sheet 2)	1	—	—	1		Nov 22/04
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	37 23/Nov/04	Bonding	1	—	—	1		Nov 23/04
b) Attach ID Patch (ref. CAR 04-003)	37 3 Dec 04		1	—	—	1		Dec 3/04
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12 Nov 27 2004	Testing (see sheet 2)	1	—	—	1		Nov 27/04
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	37 Nov 29/04	7104-25	1	—	—	1		Nov 29/04
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	37 Nov 29/04	Bonding	1	—	—	1		Nov 29/04
c) Attach 5" split patch on each end (x 4)	37 Nov 29/04		1	—	—	1		Nov 29/04

FULMAR

9

Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 23

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch: Serial No.: B 21828-06 & Inspection Stamp beside the S/N	12 Dec 2/04	Testing (see sheet 3)	1	—	—	1	4	Dec 2 2004
	12 Dec 6/04		1	—	—	1	4	Dec 6 2004

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16" high lettering and black ink: serial number (7 digits), provided by DART (refer to W/O). * Verify the integrity of the Valves (Threads/gaskets).

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams.

Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94 PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
+ 0.049 PSI for each 0.1 inch of barometric increase

+ 0.054 PSI for each 1°C of temperature decrease
- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	45 Minute Stabilizing Period			1 Hour Test									22 % Leaky	
		Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail		
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	12:15	1:00	3.00 PSI	1:00	2:00	2.94 PSI	22° 23°	29.88 29.88	-	2.94 PSI	Pass		
Re-Test Nov 27/04																
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	9:10	9:55	3.00 PSI	9:55	10:55	2.99 PSI	22° 22°	30.13 30.11	-0.009	2.98 PSI	Pass		
Re-Test																

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature: Chao P...

Date: 04/11/22

Observations: OK

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief Valve Test	PRV Serial Numbers	Opening		Closing		Pass / Fail
		Time ON	Pressure	Time	Close	
Chamber # 1	30166	8:40	3.39 PSI	8:45	3.13 PSI	Pass
Chamber # 2 (Main Seam)	32864	9:10	3.45 PSI	9:15	3.19 PSI	Pass

Chambers	Design (closing) Pressure as per above	24 Hour Leakage Test								17% humidity		
		Time On	Time Off	Read'g	Temp. Start/End		Barom. Start/End		Adjust.	Final Read'g	Pass	Fail
# 1	8.13 PSI	8:45	8:45	2.73 PSI	22°	22°	30.06	29.29	-0.377	2.35 PSI	Pass	
Re-Test												
# 2 (Main Seam)	3.19 PSI	9:15	9:15	1.95 PSI	22°	23	29.30	29.76	+0.054 +0.225	2.22 PSI	Pass	
Re-Test												

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3.5	Pass	47.0	± 0.5	47.0	Pass	24.75	± 0.5	25.25	Pass
7.3	± 0.100 *	7.5	Pass					31.0	± 0.5	31.5	Pass

* = IAW QSI 018, rev. A dated 03-05-29

Submission of Adhesive Testing:

		Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail
Peel	24 hour	Nov 17/04	Pass	Nov 17/04	Pass	Nov 18/04	Pass	Nov 29/04	Pass
	7 day	Nov 17/04	Pass	Nov 17/04	Pass	Nov 18/04	Pass	Nov 29/04	Pass
Shear	24 hour	Nov 17/04	Pass	Nov 17/04	Pass	Nov 18/04	Pass	Nov 29/04	Pass
	7 day	Nov 17/04	Pass	Nov 17/04	Pass	Nov 18/04	Pass	Nov 29/04	Pass